



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3251-041
Job Sheet 167931



Part No: D3251-041

Job Qty: 2 ea

Part Name: Centre Divider



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 12/1/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/30/17	0.00	0.00	Start Up Waterjet1		DE 17/02/03
100	Waterjet	2 pcs		11/30/17	0.00	0.69	Waterjet1		DE 17/12/03
110	QC	2 pcs		11/30/17	0.00	0.00	QC2		DE 17/12/03
120	QC	2 pcs		11/30/17	0.00	0.00	QC8		PD 17/12/07
130	Small Fab	2 pcs		11/30/17	0.25	0.47	Small Fab		SB
140	QC	2 pcs		11/30/17	0.00	0.00	QC5		17-12-11 JH
150	HandFinish	2 pcs		11/30/17	0.00	0.25	HandFinish1		BE3 17/12/11
160	QC	2 pcs		11/30/17	0.00	0.00	QC3		PS
170	Small Fab	2 pcs		11/30/17	0.00	0.47	Small Fab		SP. DAS
180	QC	2 pcs		11/30/17	0.00	0.00	QC5		38
190	Powdercoat	2 pcs		12/1/17	0.00	0.14	Powdercoat4		BR 17/12/12
200	QC	2 pcs		12/1/17	0.00	0.00	QC3		38
210	Packaging	2 pcs		12/1/17	0.00	0.00	Packaging3	5/12/17	SmB
220	QC21-SA	2 Ea		12/1/17	0.00	0.00	QC21		21 DEC 17

Part Op 100 - 1-Cut as per Dwg D3251

Descriptions: 130 - Bend as per dwg D3251

170 - Assemble as per dwg D3251

190 - START TIME: 1:00 O.V.T. 3:00 FINISH: 1:50

M 1354A

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MS20470AD4-5 M134872	36	872	0	0
170-Small Fab	D3248-1 S09863	4	0	0	0
	M2024T3S.063	7	309	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ Date: _____	DISPOSITION Rework ☐ ☐ ☐ ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐															
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 S016721 DART AEROSPACE Centre Divider		QTY Effective : _____ Disposition 																															
		MRB (QSI042) Approval 																															
		Completed By 																															
		Lead hand / Supervisor Approval Verification 																															
QC / QA Coordinator Approval 																																	
FAULT CATEGORY <table style="width: 100%;"> <tr> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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Environm: _____ Desi: _____ Doc/Da: _____ Equip/Toolir: _____ Handling/Pr: _____ Materie: _____ Internal Transpor: _____ Tribal Knowledge: _____ LOA: _____ Substation: _____ Past Expiry Date: _____ Misidentified: _____ Mfg Date: 12/04/17 Job No: 167931 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																	
OTHER : _____																																	

DART AEROSPACE LTD		Work Order: 167931
Description: Center Divider (Dual Battery Rack)		Part Number: D3251-1
Inspection Dwg: D3251	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.567	+/-0.010	21.567	1		V=DC-02	
1.250	+/-0.010	1.256	1		Tap	
5.16	+/-0.030	5.16	1		V=DC-01	
1.079	+/-0.010	1.083	1			
R0.19	+/-0.030	.19	1			
4.15	+/-0.030	4.15	1			
2.75	+/-0.030	2.75	1			
0.300	+/-0.010	.293	1			
3.71	+/-0.030	3.71	1			
1.250	+/-0.010	1.255	1			
2.97	+/-0.030	2.97	1			
10.81	+/-0.030	10.81	1			
9.90	+/-0.030	9.90	1			
18.595	+/-0.010	18.595	1			
0.983	+/-0.010	.989	1			
Ø0.257	+0.005/-0.000	Ø.259	1			
23.289	+/-0.010	23.289	1			
11.000	+/-0.010	11.004	1			
Ø0.128	+0.005/-0.000	Ø.131	1			
5.403	+/-0.010	5.203	1			
0.987	+/-0.010	.991	1			
11.77	+/-0.030	11.77	1			
4.499	+/-0.010	4.503	1			
1.375	+/-0.010	1.380	1			
2.750	+/-0.010	2.756	1			
Ø1.500	+0.005/-0.000	Ø1.504	1			
Ø0.501	+0.005/-0.000	Ø.503	1			
21.056	+/-0.010	21.056	1			
18.93	+/-0.030	18.93	1			
Ø0.125	+0.005/-0.000	Ø.125	1			
Ø0.098	+0.005/-0.000	Ø.098	1			
R0.30	+/-0.030	.30	1			
0.300	+/-0.010	.292	1			
0.063	+/-0.010	.064	1			
Grain along 21.056	N/A					

Measured by: DC	Audited by: PD	Prototype Approval:	N/A
Date: 17/12/03	Date: 17.12.07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
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